

Date: Wednesday, 19/11/2008 9:58:02 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY						
Job Number	: 43538								
Estimate Number	: 11136								
P.O. Number	:	Part Number	: D3183045						
This Issue	: 19/11/2008	S.O. No.	:	Drawing Number	: D3183 REV C1				
Prsht Rev.	: NC			Project Number	: N/A				
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: C1				
Previous Run	: 42179			Material	:				
Written By	:			Due Date	: 28/11/2008	Qty:	100	Um:	Each
Checked & Approved By	 : 08.11.09								
Comment	: Est A04.02.18 New issue KJ/DS								

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRLR1000	Delrin Round Bar 1"
	Comment: Qty.: 0.0350 f(s)/Unit Total : 3.4965 f(s)	
	Delrin Round Bar 1"	
	Material: Ø1.00 Delrin Rod	
	(M-DELRIN-R1.000)	
	Identify as D3183-9	
	Batch: <u>M108757</u>	<u>DTP 08/11/22</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL	
	Turn D3183-9 Cap as per Folio FA388	
	Deburr	<u>DTP 08/11/22</u> <u>199</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>DTP 08/11/22</u> <u>199</u>
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>ML 08/11/24</u> <u>199</u>
5.0	D31835	Bearing
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)	<u>29</u> <u>B43552</u> <u>50x</u>
	Pick:	
	Qty Part Number	Description Batch
	1 D3183-5	Bearing <u>B41045</u> <u>30x</u> <u>B43608</u> <u>20x</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 9:58:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 43538

Part Number: D3183045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

08/11/07 99

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *232A*

8/11/07

99K

50

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/01 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43538
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

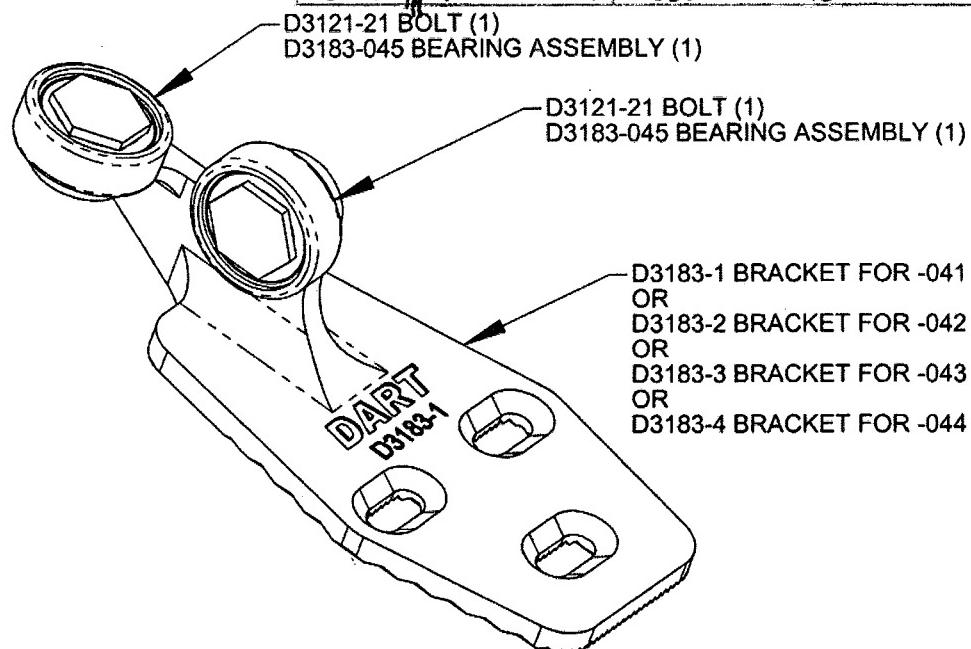
X First Article | Prototype

Measured by:	<u>DJP</u>	Audited by:	<u>JNL</u>	Prototype Approval:	N/A
Date:	08/11/22	Date:	08/11/24	Date:	N/A

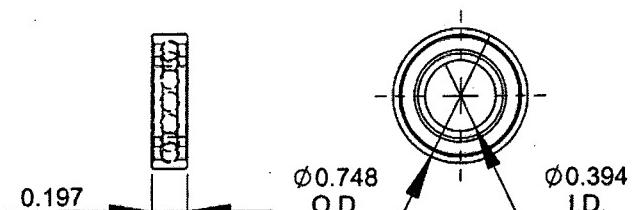
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	<i>[Signature]</i>
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	<i>[Signature]</i>

DARTCOPY IS
ISSUED

DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.03.01

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



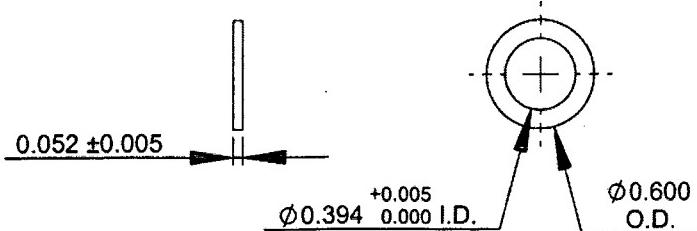
D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE,
CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ COPY
- 3) ALL DIMENSIONS ARE IN INCHES RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

D3183-7 WASHER



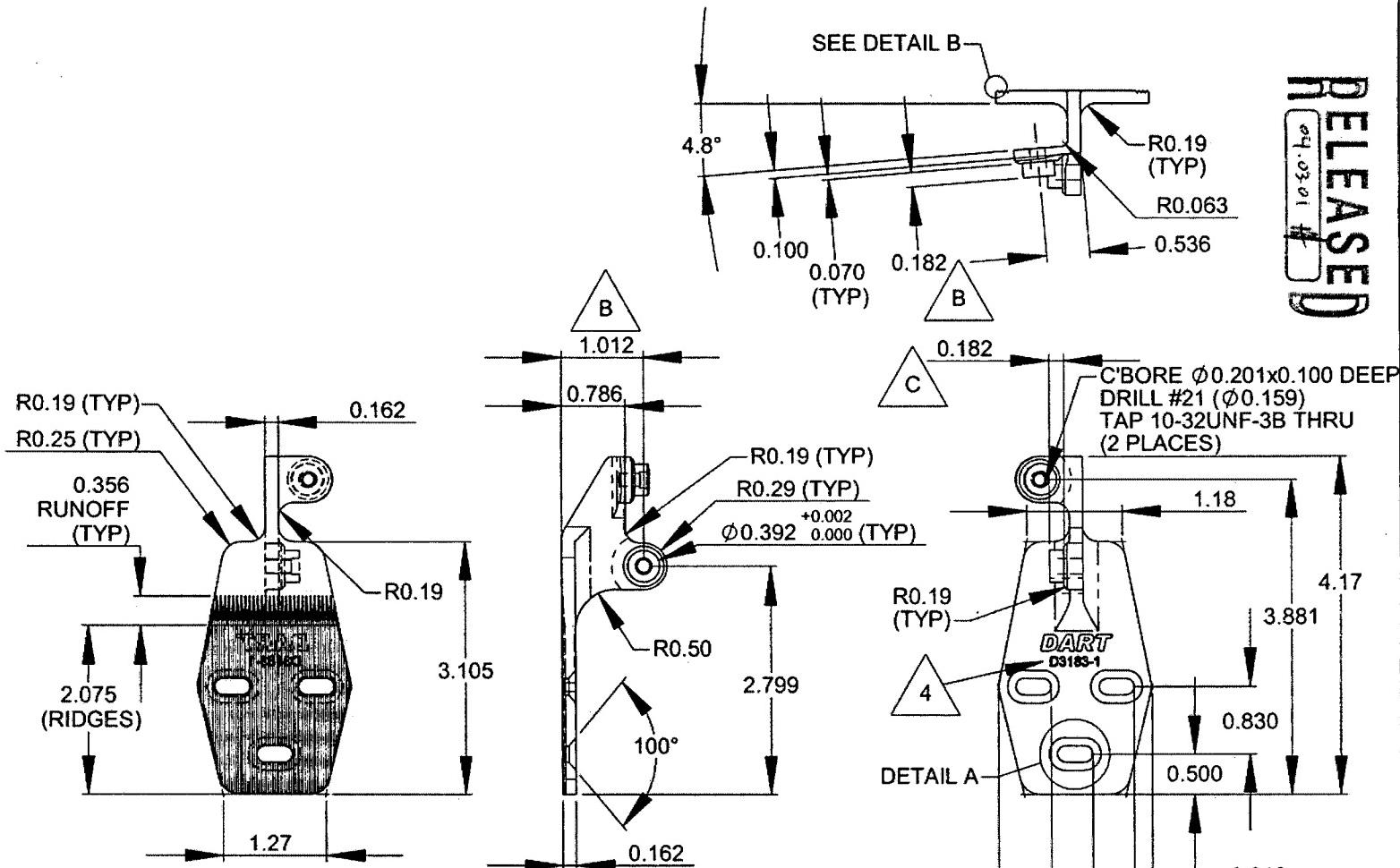
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

COPYRIGHT © 2003 BY DART AEROSPACE LTD.



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
 - 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 4) ENGRAVE DART P/N & LOGO AS SHOWN
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES

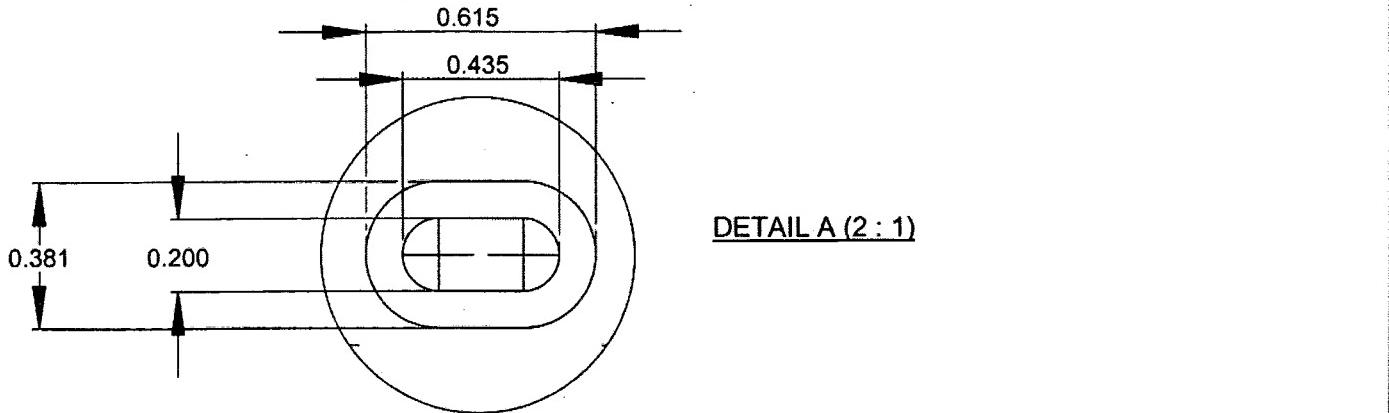
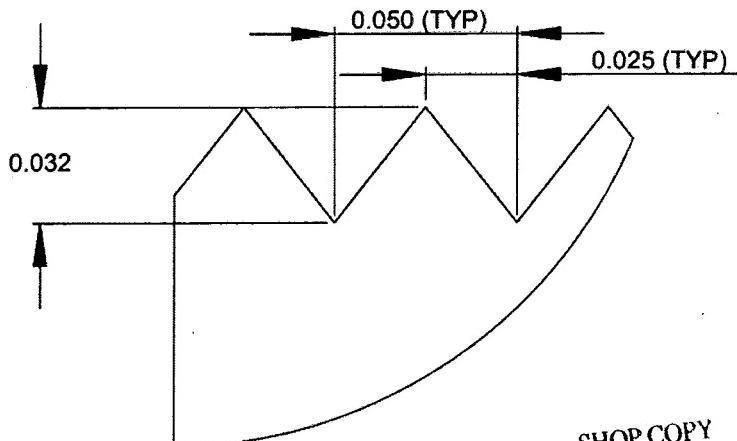
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43538

DART		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	REV C SHEET 2 OF 4
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:2
DRAWING NO. D3183		

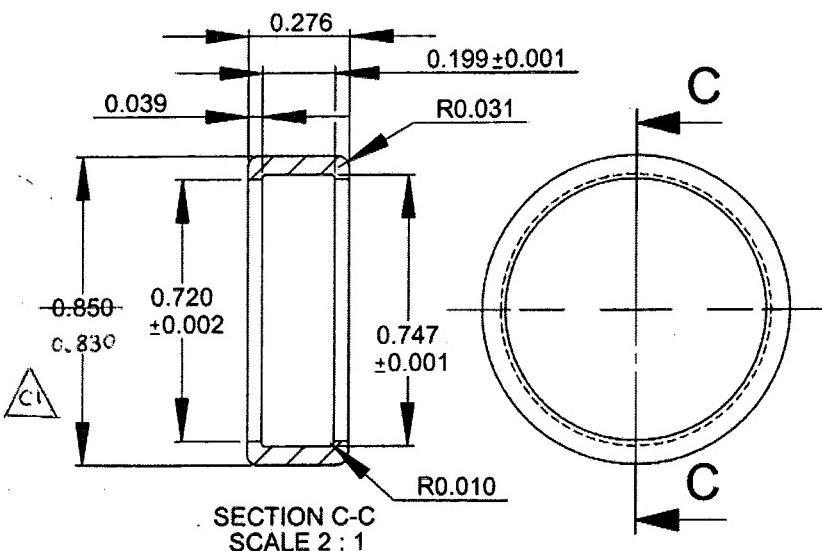
COPY IS
TO DRAFTS

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	D3183	SHEET 4 OF 4

**RELEASED**
04.03.01DETAIL B (20 : 1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 93538

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

COPYRIGHT © 2003 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.